

Work Order ID 155491

Tuesday, January 17, 2017 11:21:24 AM

155491

Page 1

Item ID: D2512 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Lid
Start Date: 1/17/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/21/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JAN 18 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2512	H

100 Weld per dwg A/R S.S. rod Batch: 4136695 0.00
100 Large Fab
Memo 0.55
Large Fab 1- Weld ribs as per Dwg D2512 using Welding Jig DT 9436
2- WELD MESH AND REMOVE SECTIONS OF MESH WHERE INDICATED AS PER DWG

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110 QC Memo 0.00
Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00
120 QC Memo 0.00
Quality Control

DAS
43
9-89 FEB 12 2017

1 FEB 23 2017 PC

1 FEB 23 2017 PC

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By _____		
							Lead hand / Supervisor Approval Verification _____		
							QC / QA Coordinator Approval _____		

Root Cause				FAULT CATEGORY						
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
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Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐							
Misidentified	☐	Past Due	☐							

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FINISH TIME: _____

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140	HandFinishing	0.00							
140	Memo	0.29							
Hand Finish	Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4								
Hand Finishing	Batch: <u>M136206</u>								
150	QC3- Inspect Part Finish	0.00							DAS 38 9-88
150	Memo	0.00							
QC									
Quality Control									FEB 24 2017
160	Identify as per dwg & Stock Location <u>cell 6</u>	0.00							
160	Memo	0.00							
Packaging									
Packaging									

0205 541-044/B155617

1 of 2 1/17/2017

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89 FEB 24 2017

DAS
21
9-89 FEB 24 2017

DQA: _____ Date: _____



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Picklist Print

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Work Order ID: 155491

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Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 1/17/2017

Required Date: 1/21/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
IPP Rev:N 06.04.05 Added level21 EC
IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
VERIFIED BY:DD
IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
by:EC IPP Rev:R
10.06.29 added pressure wash DD verf:EC IPP REV:S 12.07.27 AS
PER DWG REV.F DD VERF:EC IPP REV:T 12.08.08 AS PER DWG
REV.G DD VERF:EC IPP REV:U 16.11.03 AS PER DWG REV.H
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-1		Manufactured	No			100	Each	13.0000	2	2			
✓ *D2232-1*									**			DAS 43 9-89	FEB 11 2017
Basket Hinge													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				13					
				146596				8					
				153489				5					
D2236		Manufactured	No			100	Each	8.0000	4	4			
✓ *D2236*									**				
Lid Rib													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				8					
				150484				4					
				153694				4					

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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, January 17, 2017 11:21:23 AM

Page 2

Work Order ID: 155491

155491

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 1/17/2017

Required Date: 1/21/2017

Start Qty: 1.00

Required Qty: 1.00

D2506

Manufactured No

100

Each

10.0000

1

1

✓ ***D2506***

Label Plate

CC 17-2-10

Location

Loc Qty

Loc Code

WA004

10

137315

1

148587

9

D2512-3

Manufactured No

100

Each

6.0000

2

2

✓ ***D2512-3***

Rib

CC 17-2-10

Location

Loc Qty

Loc Code

WA004

6

152758

6

D2512-5

Manufactured No

100

Each

18.0000

6

6

✓ ***D2512-5***

Rib

CC 17-2-10

Location

Loc Qty

Loc Code

WA004

18

150423

6

154046

12

D2512-7

Manufactured No

100

Each

9.0000

3

3

✓ ***D2512-7***

Rib

CC 17-2-10

Location

Loc Qty

Loc Code

WA004

9

146487

3

154049

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval ☐	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, January 17, 2017 11:21:23 AM

Page 3

Work Order ID: 155491

155491

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 1/17/2017

Required Date: 1/21/2017

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 86.0000 2 2

✓ ***D2581***

Mounting Bracket

**

CC 17-2-10

Location

Loc Qty

Loc Code

WA004

86

132771

1

136270

2

139082

2

147603

2

148944

23

152803

48

154019

8

2x

✓ D3825-043

D3825-043

Rib Assembly (Basket End, Lid)

D3832-13

Manufactured No

100

Each

0.0000

2

2

B148946

**

CC 17-2-10

D3832-13

Mesh (Lid)

D3833-7

Manufactured No

100

Each

0.0000

1

1

~~B136612~~

**

FEB 23 2017 B157763-1

D3833-7

Manufactured No

100

Each

20.0000

2

2

✓ ***D3833-7***

Mesh (Lid End)

**

Location

Loc Qty

Loc Code

WA006

20

153534

8

154134

12

2x

DQA: _____ Date: _____

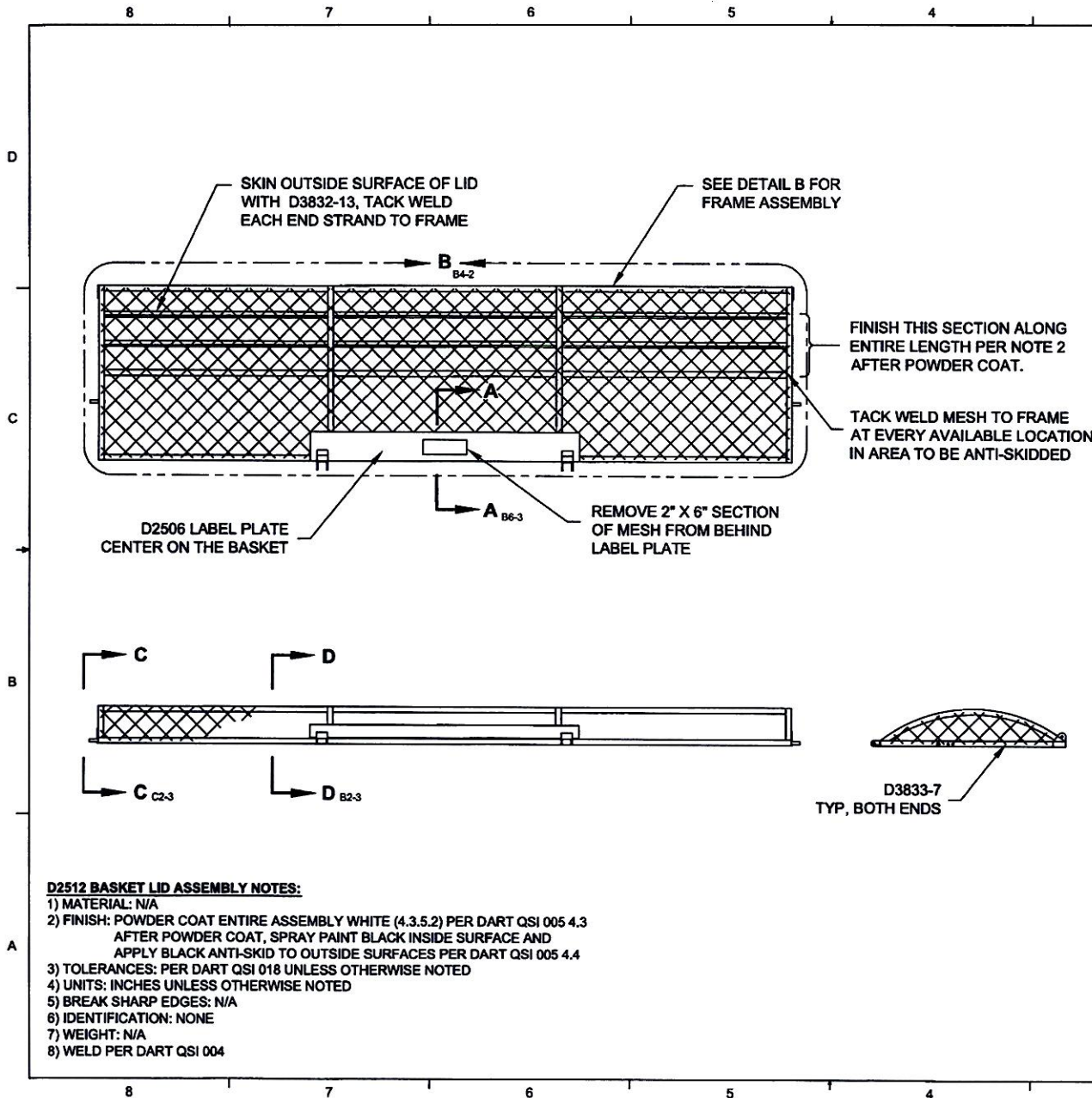


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

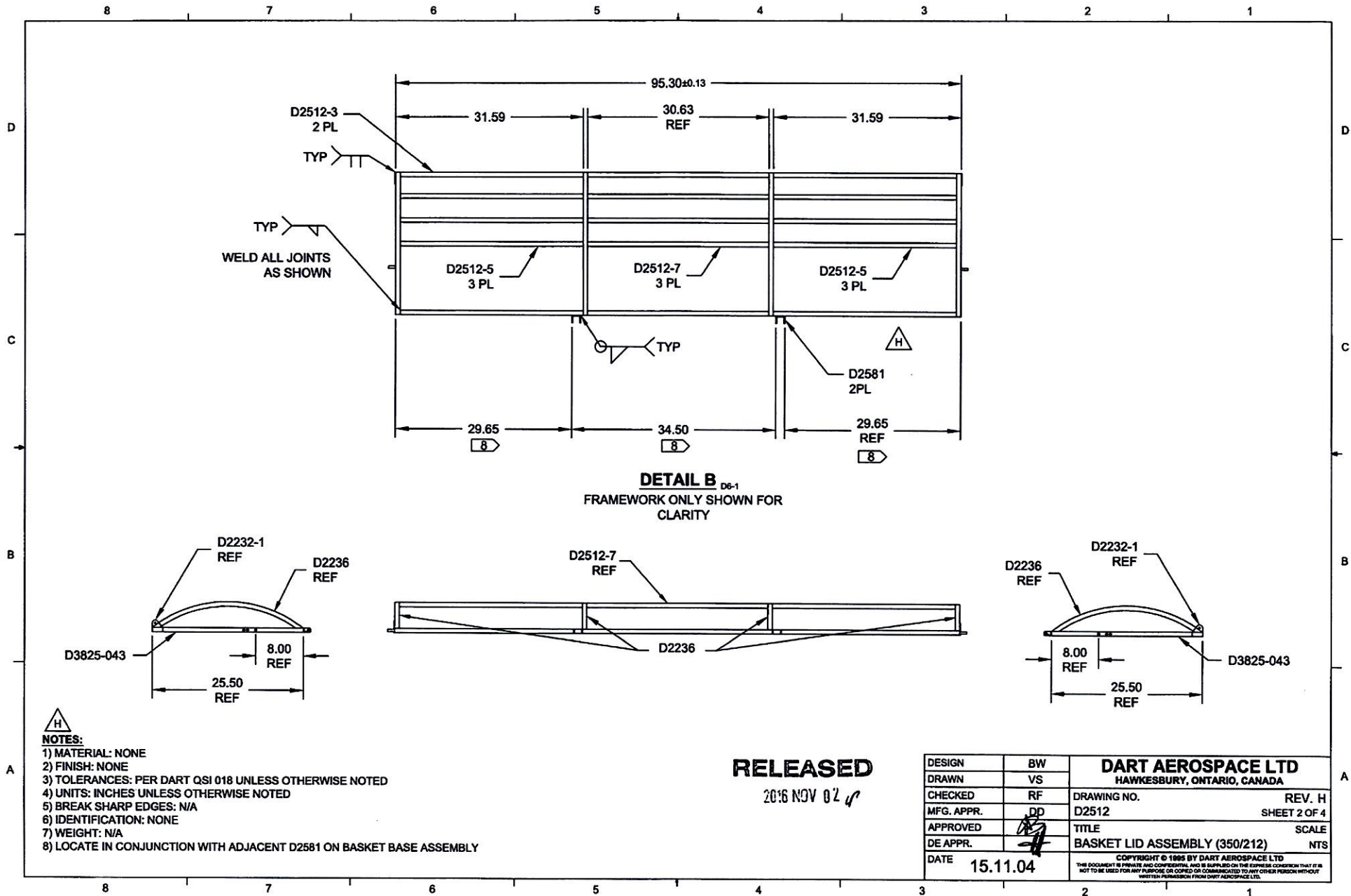
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

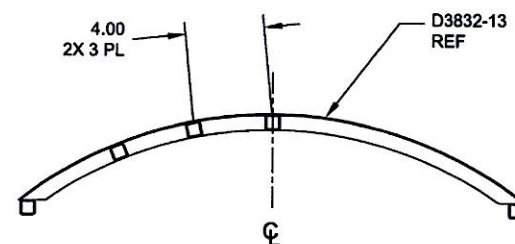
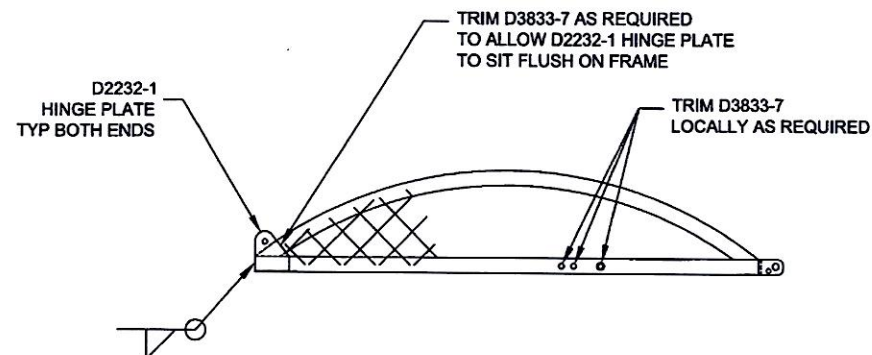
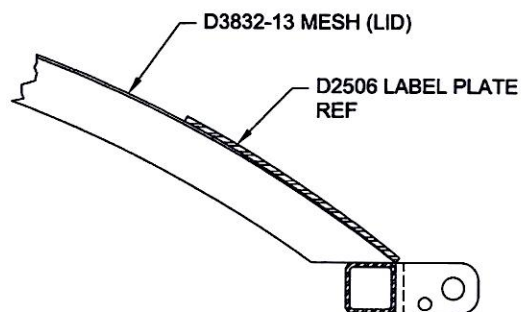


QTY	PART NUMBER	DESCRIPTION
X	D2512	BASKET LID ASSEMBLY
2	D2512-3	RIB
6	D2512-5	RIB
3	D2512-7	RIB
2	D2232-1	HINGE PLATE
4	D2236	RIB
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3825-043	RIB ASSY (BASKET END, LID)
1	D3832-13	MESH (LID)
2	D3833-7	MESH, LID END

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155491 MJS
17-01-18
RELEASED
2016 NOV 02
EON 16-313 97

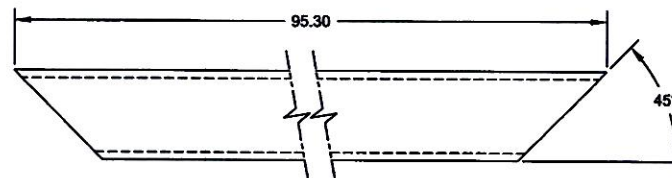
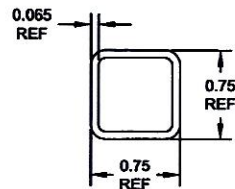
H	REMOVED D2012-117 (ZN A8-2, C3-2)	VS	15.11.04
G	CORRECTED TYPO: D3825-043 WAS D3825-041 (ZN D3-1, B8-2, B1-2)	MB	12.07.26
F	GENERAL REVISION; REFORMATED DWG; DELETED DETAIL E AND RELATED NOTES IN VIEW C-C. REASON: PAR10-50.	MB	12.05.11
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BY	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. H
MFG. APPR.	DD	D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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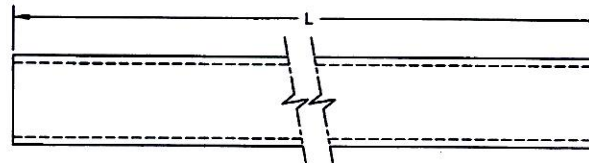
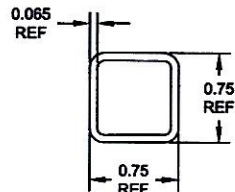


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CHECKED	RF	DRAWING NO.	REV. H
MFG. APPR.	DD	D2512	SHEET 3 OF 4
APPROVED	AK	TITLE	SCALE
DE APPR.	TH	BASKET LID ASSEMBLY (350/212)	NTS
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D2512-3 RIB



D2512-X RIB

DART PART NUMBER	L
D2512-5	30.84
D2512-7	30.63

D2512-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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CHECKED	RF	DRAWING NO.	REV. H
MFG. APPR.	PD	D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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